

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010044**Date Inspected:** 07-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	OBG				

**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD****ULTRASONIC INSPECTION**

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF UT department for detection of planar transverse indication. The Ultrasonic inspection was performed on following weld joint.

1)OBG segment 1AE-1BE (Bottom panel)

OBE1A-008

2)OBG segment 2AE-2BE (Bottom panel)

OBE2A-004

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Ultrasonic Testing (UT) performed utilizing scanning pattern A, B, C and D (Fig 6.7)

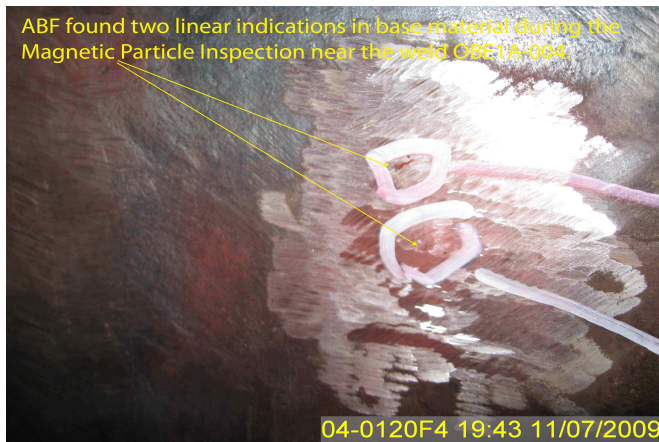
See Caltrans Ultrasonic Transverse Indication Evaluation sheet dated 11/07/2009 for further information on inspections.

### MAGNETIC PARTICLE INSPECTION

This QA Inspector performed Magnetic Particle Testing (MT) in conjunction with ABF Magnetic Particle Testing (MT) department for detection of planar transverse indication.

Magnetic Particle Testing (MT) performed on repair areas of weld OBE1A-004, OBE1A-002 and OBE1A-009. During the Magnetic Particle Inspection This QA observed ABF Inspector found two linear indications which is in base material approximately 70mm away from the weld OBE1A-004 towards OBG segment 1AE. The 'Y' location measured approximately 7780mm. The length of indication measured approximately 5mm. for additional information see the attached photo.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang +(86) 150.0042.2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

**Reviewed By:** Dawson,Paul

QA Reviewer